



Work Order ID 62678


Wednesday, October 06, 2010 2:56:18 PM

Page 1


Item ID:	D2646	Accept		Setup	Start	
Revision ID:						
Item Name:	Aft Cap				Stop	
Start Date:	10/6/2010	Start Qty:	60.00	Cust Item ID:		
Required Date:	10/15/2010	Req'd Qty:	60.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2646	Rev C								

100		0.00							
	PURCHASING								
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 12711								
	note required								

CX 10/10/07 (60)

110		0.00							
	Receive & Inspect for Damage & Mat'l Certs								
Packaging	Memo	0.00							
Packaging	Ensure Material Release Note is attached								

Perf/4 (60)

120		0.00							
	QC6- Inspect dimensions to drawing								
QC	Memo	0.00							
Quality Control									

Solulog

counted
(60)
AS2019

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62678

Wednesday, October 06, 2010 2:56:18 PM



Page 2

Item ID: D2646

Accept



Setup Start



Revision ID:

Item Name: Aft Cap

Stop



Start Date: 10/6/2010 Start Qty: 60.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 60.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill using DT8026 as per Dwg D2646. □2-Open holes to .297 as per Dwg D2646. □3-Deburr

⇒ m, L 10/11/10

60x

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/10/10

canon
x60

Handwritten signature

150

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

⇒ JH

10/11/10 x60

Handwritten signature

Handwritten signature

W/O: 62678		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/11/16	150	took 6 to stock 25 unprinted see w/o 63830	WZ	10/11-16	6	W 10/11/16	

Part No: D2646 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62678

Wednesday, October 06, 2010 2:56:18 PM



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Item ID: D2646	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Aft Cap					
Start Date: 10/6/2010	Start Qty: 60.00		Cust Item ID:		
Required Date: 10/15/2010	Req'd Qty: 60.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M15291</i> Memo START TIME: <i>1:00</i> <i>3:20</i> FINISH TIME: <i>1:30</i> <input type="checkbox"/> OVEN TEMPERATURE:	0.00 0.00							<i>54</i> <i>BL 10-11-16</i>
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>m</i> <i>10</i> <i>11</i> <i>16</i> <i>(54)</i>
180 Small Fab Small Fab Small Fab	Small Fab Memo Install inserts as per Dwg D2646	0.00 0.00							<i>=> M 10/11/19</i> <i>54</i> <i>Ø</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

Wednesday, October 06, 2010 2:56:18 PM

Accept

[illegible][illegible]

Customer:

[illegible]

1. **Introduction**

2. **Background**

3. **Methods**

4. **Results**

5. **Conclusion**

6. **References**

7. **Appendix**

8. **Table 1**

9. **Table 2**

10. **Table 3**

11. **Table 4**

12. **Table 5**

13. **Table 6**

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229. <

[illegible]

Date: _____

**Insp.
Stamp**

00000000000000000000

Quality Control

00000000000000000000


Packaging



Quality Control

ml 10 11 19 (54)

54 ~~0~~ _____

ca 10/11/22 

10-14-19
(34)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, October 06, 2010 2:56:22 PM

Page 1

Work Order ID: 62678

Parent Item: D2646

Parent Item Name: Aft Cap



Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: G 05.08.22 Hole size revised in Step 5 KJ/JLM
IPP Rev:H Changed Inserts 07-02-19 JLM
IPP rev I changed inserts 07.06.11 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-130		Purchased	No			110	Each	1,746.000	2	120			
Insert													

Location

Loc Qty

Loc Code

FP
115079
ST282
113238
115502
115581

729
729
1017
17
500
500

M115911

X120

D2646P

Purchased

No

180

Each

0.0000

1

60



Aft Cap



362678 07/10/11/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

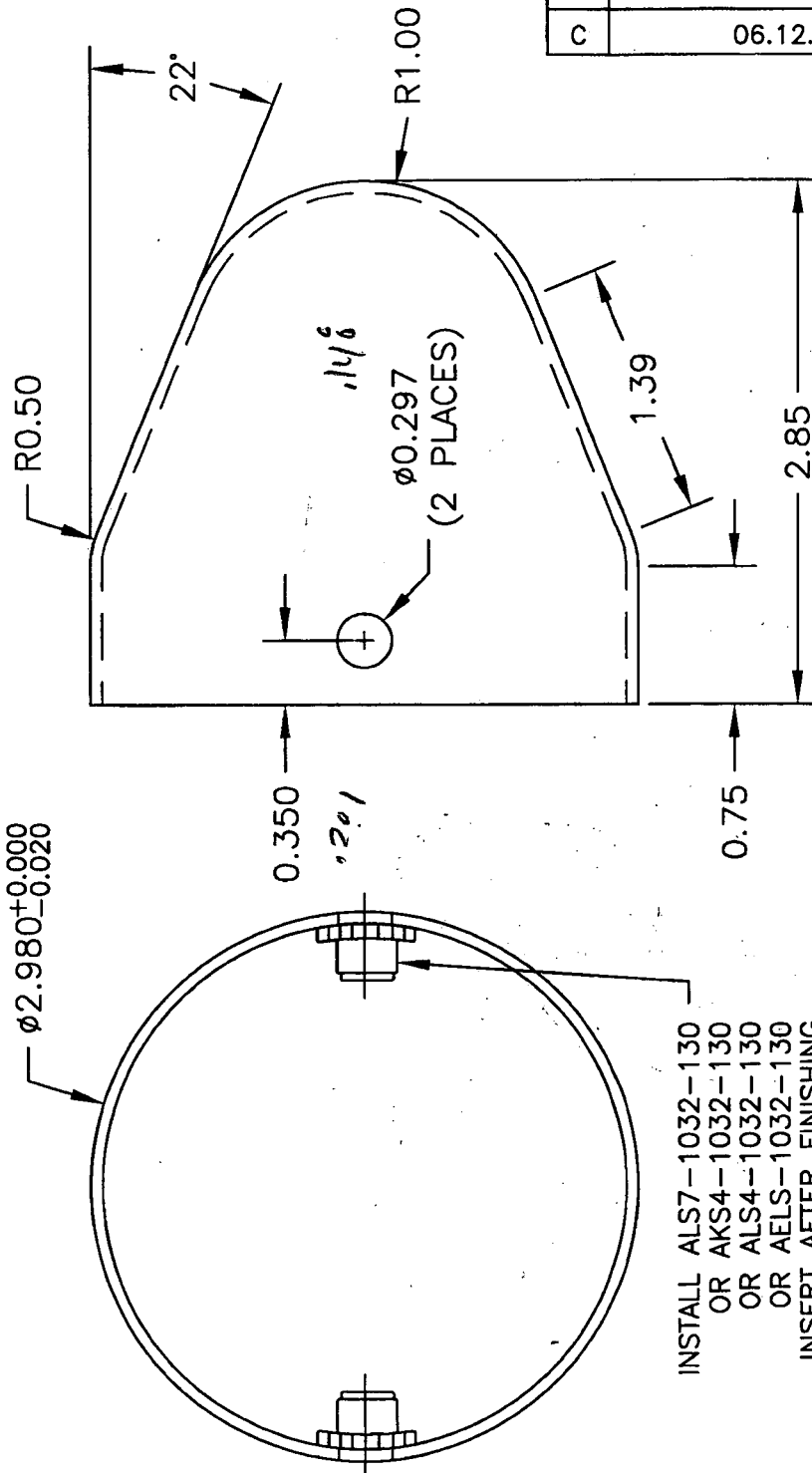
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN DS		DRAWN BY PH		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D2646	REV. C SHEET 1 OF 1
DATE 06.12.20		TITLE AFT CAP		SCALE 1:1	
A	97.03.25		NEW ISSUE		
B	05.04.01		CHANGE TO CLOSED INSERTS		
C	06.12.20		CHANGE TO OPEN ENDED INSERTS		



RELEASED

07.02.12

ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

D2646 AFT CAP

- 1) MATERIAL:
- 2) FINISH:
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP
REV.
ENG.
UNCON.
SUBJECT
WITH
WORK
NO. *CA 178*
BS 10-10-66

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO12711**

Purchase Order Date 10/07/10

PO Print Date 10/07/10

Page Number 1 of 1

Order From :

VC-SIE001

SIEG'S MANUFACTURING LTD.
6236 - 205 STREET
LANGLEY, BC V2Y 1N7
CA

Contact Name

Vendor Phone

604 530 7455

Vendor Fax

604 530 7490

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

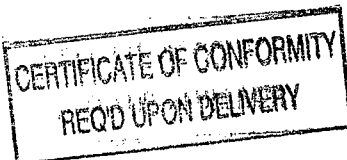


Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2646P	Aft Cap	10/22/10 Yes	60.00 Each	FedEx PI ppd	\$5.8900	\$353.40

Special Inst: SPIN AS PER DWG D2646 REV.C
B62678

PO Total:

\$353.40



Change Nbr:

1

Change Date: 10/07/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



Sieg's Manufacturing Ltd. Packing Slip

Metal Spinning & Fabricating

6236 205 Street

Langley, BC, Canada V2Y 1N7

Phone:(604)530 7455 Fax:(604)530-7490

Packing Slip No.:

38464

Date:

10/28/2010

Page:

1

Sold to:	Ship to:
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7
Order No.: PO12711	Sold By: KAULBARS, ARLA
Shipped By: FEDEX	Ship Date: 10/28/2010
Tracking No.:	

Item No.	Unit	Description	Quantity
D2646P	Each	AFT CAP	60

Comment:

Photo not attached



Alcoa Mill Products

1480 Manheim Pike
Lancaster Pa 17601

Certification of Test Results

SOLD TO

Barry A. Dorfman & Co.
2014 Roscomare Road
Los Angeles, California 90077

SHIP TO

Siegs Manufacturing
6236 205th St.
Langley, British Columbia
V2T 1N7 Canada

CERT NO 0001034239

DATE 9/19/2008

SKID NO 760563

SKID WGT 6,409

PAGE 1 OF 1

ORDER NO	LJ5630	PO NO	745
ITEM NO	1	PART NO	050393-8
ALLOY	1100	TEMPER	O
Gauge	.06300	WIDTH	48.0000
		FORM	COIL
		LENGTH	0.0000

MILL FINISH
NON ANODIZE QUALITY
OUT: STANDARD MILL FINISH
IN: STANDARD MILL FINISH
NOT EMBOSSED

LOT: 386186 COIL: A01 DROP: 8P03289

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
8P03289	0.12	0.51	0.13	0.01	0.01	0.01	0.01	0.01	0.01

HEAD ULTIMATE STRENGTH 13.8 KSI
 TAIL ULTIMATE STRENGTH 13.5 KSI
 HEAD YIELD STRENGTH (OFFSET = .2%) 5.6 KSI
 TAIL YIELD STRENGTH (OFFSET = .2%) 5.5 KSI
 HEAD RLG IN 2 IN., AT FRACTURE 30 %
 TAIL RLG IN 2 IN., AT FRACTURE 30 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-07
 CHEMISTRY EXPRESSED AS % W/W FOR EACH REPORTED ELEMENT
 MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-06

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:

ASME SB209 1100 O, ASTM B209-07 1100 O

** END OF CERTIFICATION **

→ ACCEPTABLE BASED ON SIMILARITY WITH
 OTHER "H-DRAWING" SPEC CALLING
 ASTM B209 FOR SHEET METAL, ALUMINUM.

10.11.08
CHUR

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product. Certification of test results shall not be reproduced except in full.

These commodities, technology, and software exported from the United States in accordance with the Export Administration Regulations, Division 3000, E.O. 12812, as amended.

Authorized By:

JEFF KREADY, LAB SUPERVISOR



Sieg's Manufacturing Ltd.

6236 205 Street Langley, B.C. Canada V2Y 1N7

Ph#: (604)530-7455 fax#: (604)530-7490

arla@siegsmfg.com

INSPECTION REPORT

Date: Oct 28

Customer: Dart Aerospace

Packing Slip: 38464

Part#:	Quantity	Material	Check holes	Insp. By.
D2646 P	60	1100 - 0.14g	N/A	TE

Notes:

Material Certification Attached: ✓